

Work Order ID 127326

December-17-14 1:13:32 PM

127326

Page 1

Item ID: 646.9711

Revision ID:

Item Name: Blade

Start Date: 12/17/14 Start Qty: 10.00

Required Date: 12/17/14 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 14-12-19 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.9700	C (ECN)

100

0.00

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 4.625"

0.00

10 Ø OK 2015-01-07

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB135

DWG REV: C

FOLIO REV: C

0.00

15-01-09

10 Ø DAS 37 9-89 15-01-10

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL
BURRS ON CUTTING EDGE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127326

December-17-14 1:13:32 PM

127326

Page 2

Item ID: 646.9711

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Blade

Start Date: 12/17/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Outsource process - Heat Treat

0.00

140

Outsource1

Memo

0.00

Outsource process - Heat Treat

HEAT TREAT AS PER DWG, SEE NOTE #3

ISSUE P/O: 27040*Handwritten signature and date: 15/01/09**Handwritten signature and date: 15/01/12*100100CL 15/01/13 10**DAS
08
9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127326

127326

Page 3

December-17-14 1:13:32 PM

Item ID: 646.9711 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade
 Start Date: 12/17/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Spray Painting per QSI005 4.2	0.00							
160									
SprayPaint	Memo	0.00							
Spray Painting	PRIME AS PER DWG, SEE NOTE #4								
	PRIMER BATCH: <u>131 121</u>								

10X 80 15-01-26

10 38 9-89

JAN 26 2015

10 15-01-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
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Material									
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Page 4

15-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Picklist Print

December-17-14 1:13:32 PM

Page 1

Work Order ID: 127326

127326

Parent Item: 646.9711

646.9711

Parent Item Name: Blade

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased		No		100	f	106.9000	0.386	5			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

Location

Loc Qty

Loc Code

MAT010

106.9

M126438

105.5

M127494

1.4

5 JFC 2015-01-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04559

SHEET 1 OF 1

DWG NO. 646.9700.

REV: C

PREPARED BY D. MEJIA

DATE: 06/11/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY: ENGR

[Signature]

MFG

[Signature]

QC

[Signature]

EFF.

NEXT ORDER

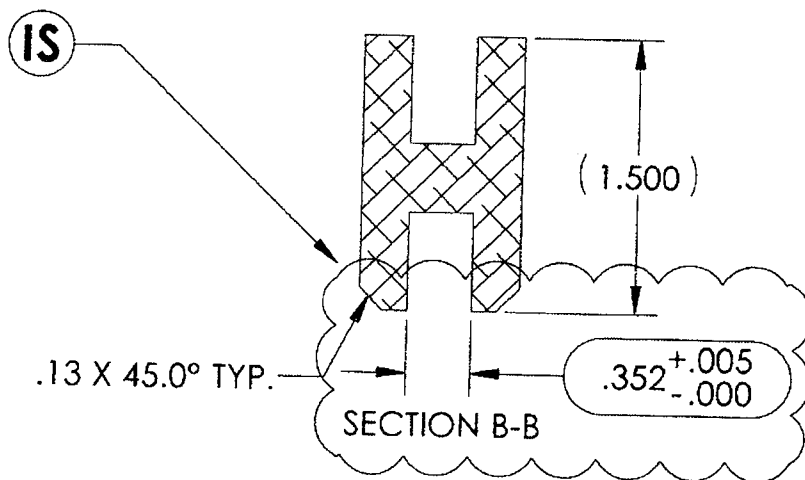
TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: ADDED DIMENSION AND TOLERANCE

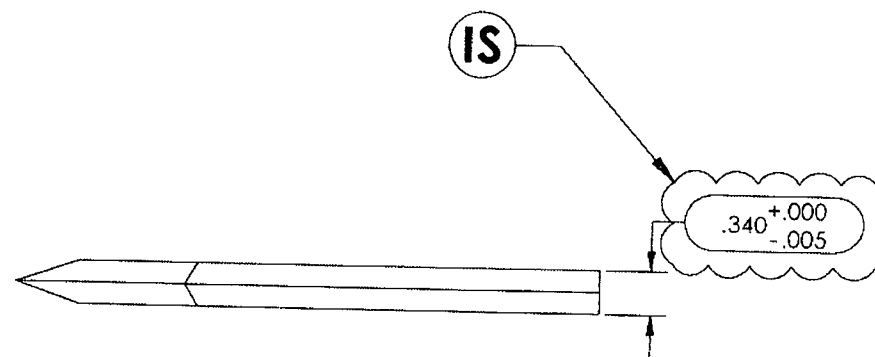
ECR:

D-14-05

SHEET 2, ZONE D7 IS:



SHEET 5, ZONE B5 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 127326 MJS
14-12-19

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

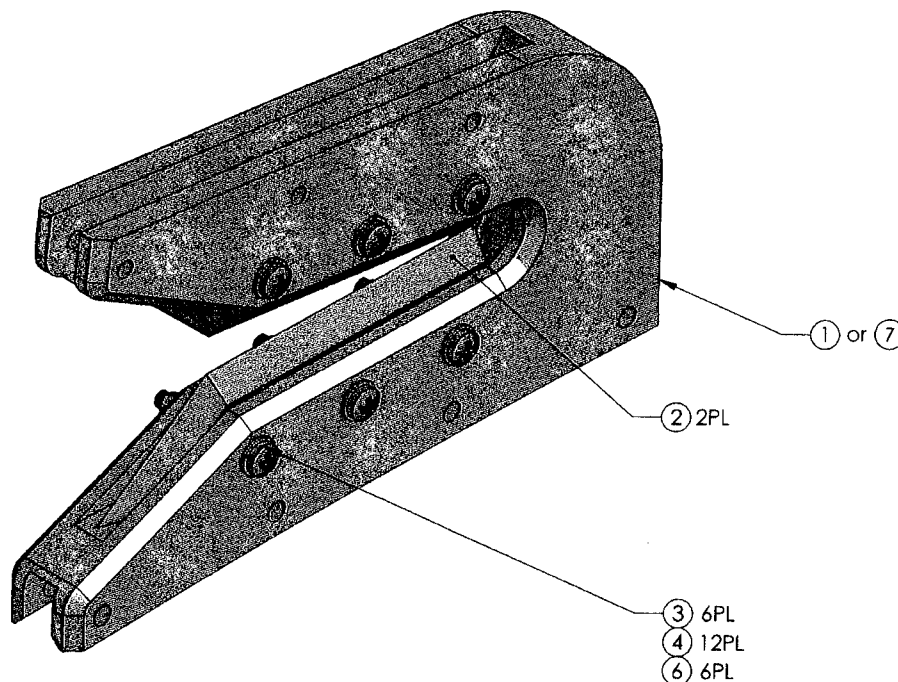
☐ YES ☒ NO

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PRODUCTION REVISION: PR2		INAC
2	INITIAL RELEASE	02/27/89	P. BRAVO
3	INCORPORATED ECN 02744, 03036, 03912	06/06/13	P. BRAVO
4	INCORPORATED ECN 03767	07/03/13	P. BRAVO
5	INCORPORATED ECN 04059	08/09/13	P. BRAVO

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.



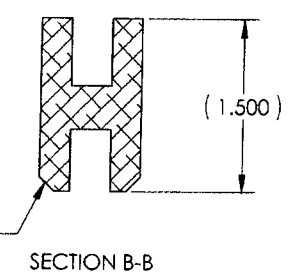
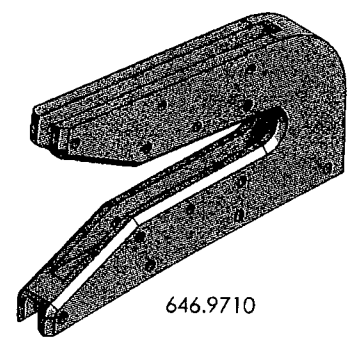
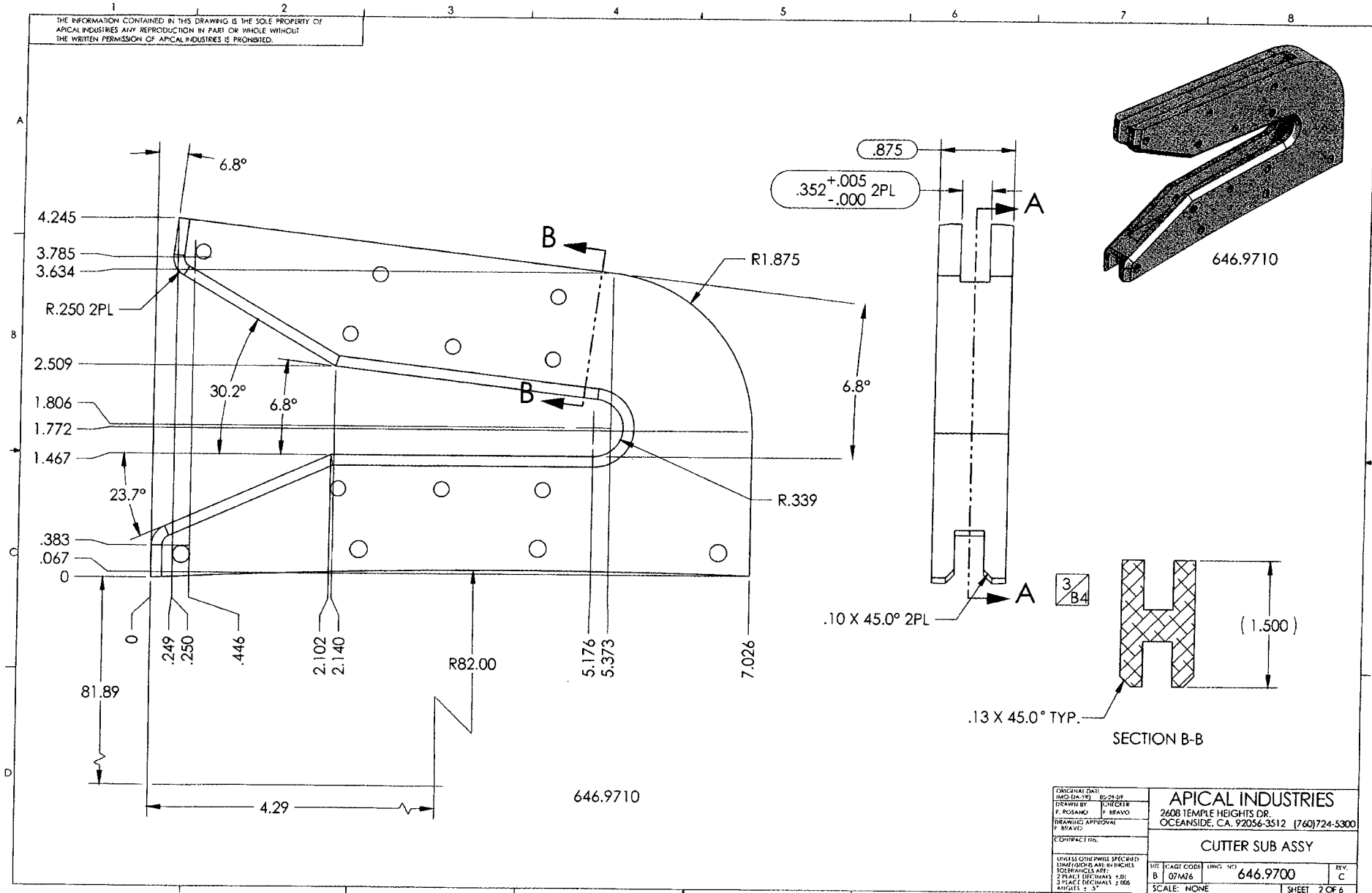
646.9701
or
646.9702

UNINCORPORATED ECN(s)

04559

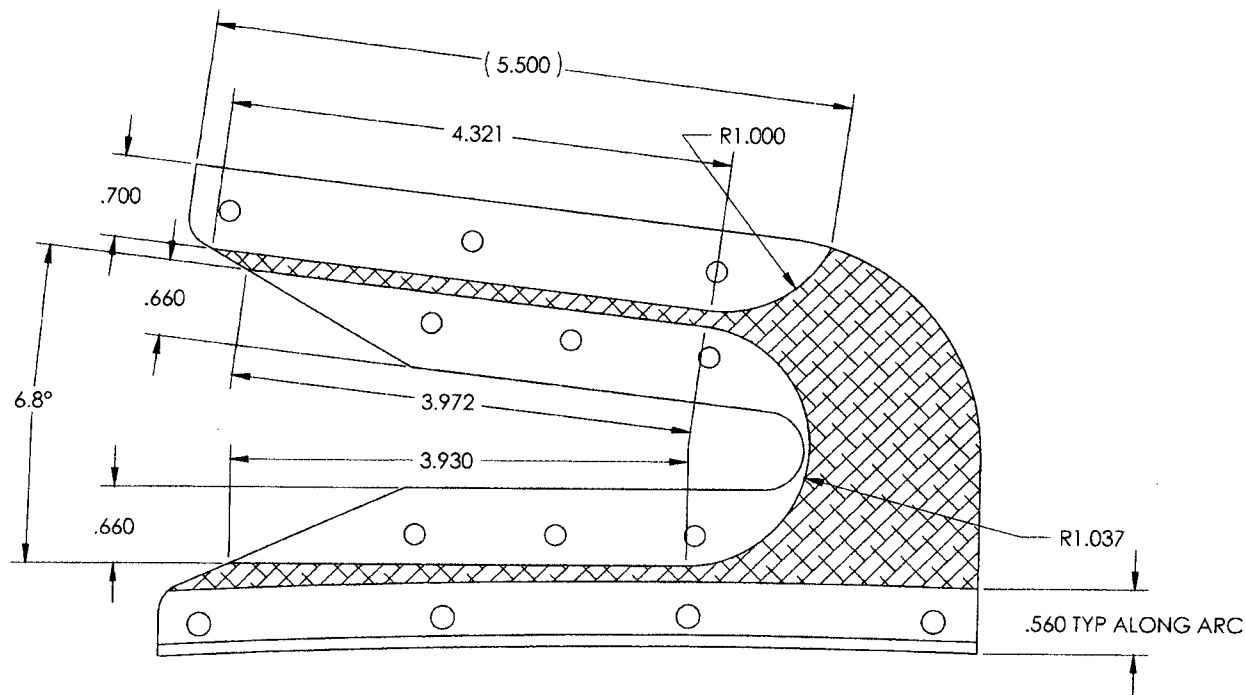
1	7	646.9712	BODY (U CHANNEL)	△	△/△
6	6	601.1541	LOCKNUT	MS21047-08	
A/R	A/R	5	601.2764	RTV, LOCTITE 598	
12	12	4	601.2764	WASHER	HA5114P1N33P
6	6	3	601.2765	SCREW	MS27039-0819
2	2	2	646.9711	BLADE	
	1	1	646.9710	BODY	△
			646.9702	CUTTER SUB ASSY (U CHANNEL)	△
			646.9701	CUTTER SUB ASSY	
9702	9701	FIND #	PART #	DESCRIPTION	MAT'L SPEC.
QTY	PARTS LIST				
NEXT ASSY (S)	APICAL INDUSTRIES				
646.9600	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300				
	CUTTER SUB ASSY				
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 ANGLES ±.5				
	8	07/06/16	646.9700	REV.	C
	SCALE	NONE	SHEET	1 OF 6	

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ORIGINAL DATE: 05-24-88		APICAL INDUSTRIES	
DRAWN BY: J. CHENIE		2608 TEMPLE HEIGHTS DR.	
F. ROSANO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL: F. ROSANO		CUTTER SUB ASSY	
CONTRACT NO.		REV. C	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES		SHEET 2 OF 6	
TOLERANCES ARE:			
2 PLACE DECIMALS ± .01			
3 PLACE DECIMALS ± .005			
ANGLES ± 5°			

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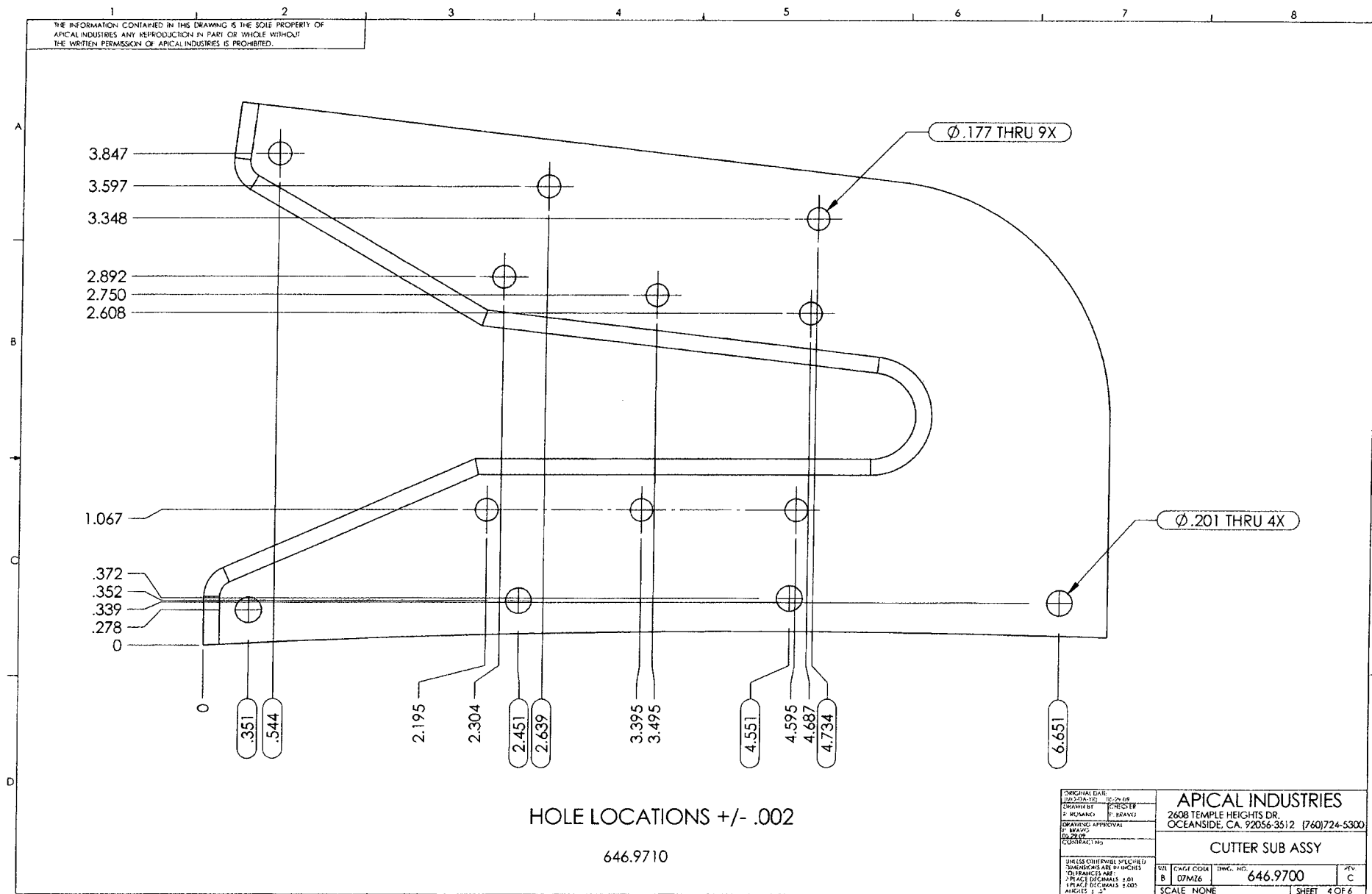


SECTION A-A $\frac{2}{C6}$

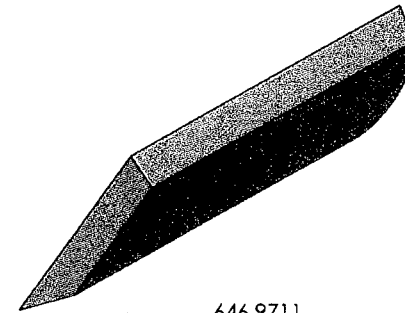
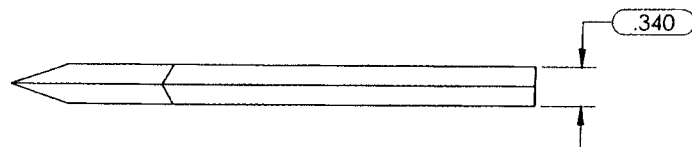
646.9710

ORIGINAL DATE ENCLOSURE 05-24-05		APICAL INDUSTRIES	
DRAWN BY: CHECKED		2608 TEMPLE HEIGHTS DR.	
P. POKAHO P. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL		CUTTER SUB ASSY	
P. BRAVO			
05-24-05			
C. D. BRACCHI HO			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FOR FRANCES & ART 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV	REV
		B 07M26	646.9700 C
		SCALE NONE	SHEET 3 OF 6

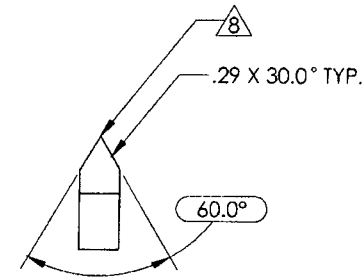
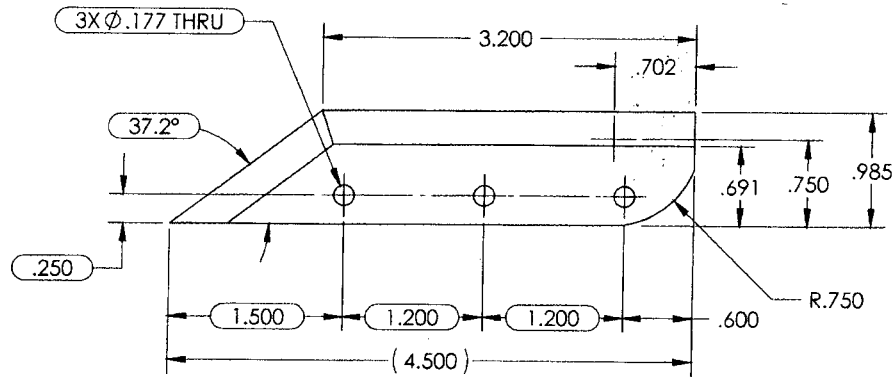
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646.9711



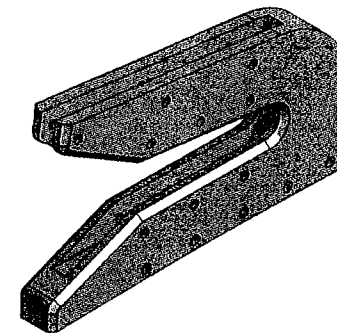
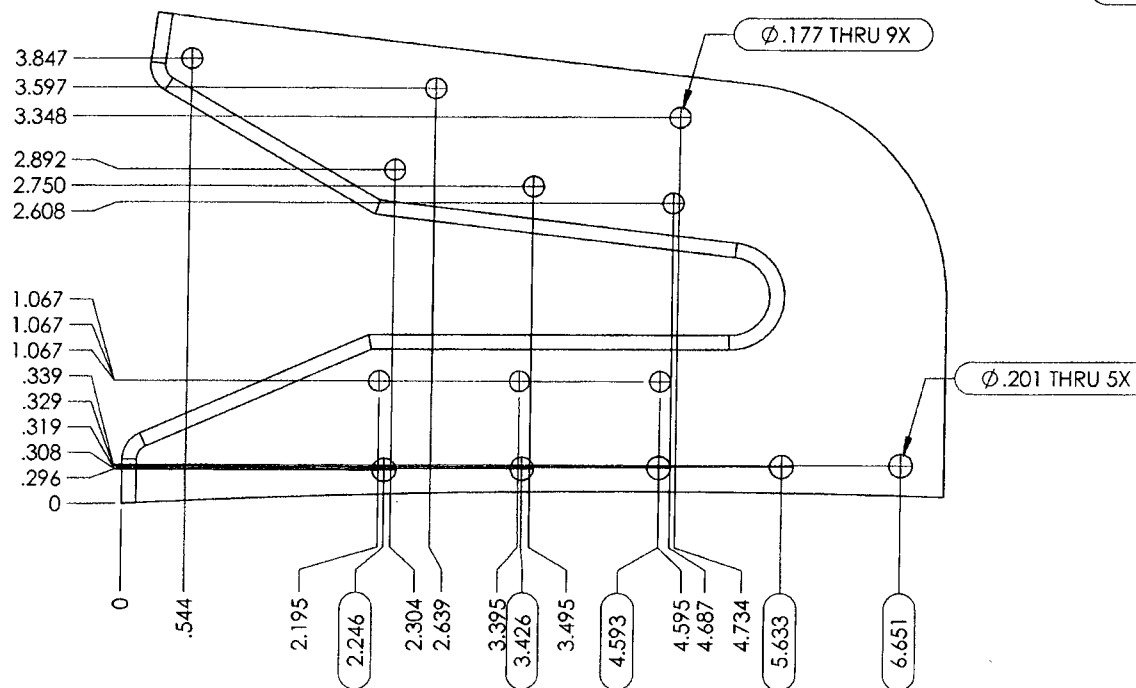
646.9711

ORIGINAL DATE: 05-29-09			
DRAWN BY: P. BEAVER			
CHECKED BY: P. BEAVER			
DRAWING APPROVAL: P. BEAVER			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED			
DIMENSIONS ARE IN INCHES			
TOLERANCES ARE:			
2 PLACE DECIMALS: ±.01			
3 PLACE DECIMALS: ±.005			
ANGLES: ±.5°			
DWG. NO.	CAGE CODE	SCALE	REV.
646.9700	07M16	NONE	C
SHEET 5 OF 6			

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

CUTTER SUB ASSY

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646.9712 $\triangle 9$

646.9712

ORIGINAL DATE: 05-79-09		APICAL INDUSTRIES	
DRAWN BY: K. ROSANO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. SHAW		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: P. BEAVO 05-28-09		CUTTER SUB ASSY	
CONTRACT NO.		REV. C	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES HOLE FINISH: AS BUILT 2 PLACE DECIMALS ± .02 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET: 07/02/06	DWG. NO: 646.9700
SCALE: NONE		SHEET: 6 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27040**

Purchase Order Date 1/13/2015

PO Print Date 1/13/2015

Page Number 3 of 3

Order From :

VC-MET004

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450 473 1884

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

127326

646.9711 BLADE

1/23/2015

10.00 ✓

\$0.00

\$0.00

Yes

1/23/2015

FINISH: HEAT TREAT TO 58-62 RC
ROCKWELL HARDNESS

PART ARE MADE FROM AISI A2 TOOL STEEL

PLEASE NOTE: DETAIL C OF C REQUIRED

8015-01-26

Line Total:

\$0.00

71401-45

PROCUREMENT
QUALITY CLAUSES

1/23/2015

1.00

\$0.00

\$0.00

No

1/23/2015

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A020 non-destructive test/inspection identification

A021 dart aerospace processing

A024 process certifications

A026 certification of material conformance

Line Total:

\$0.00

PO Total:

\$0.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr:

2

Change Date: 1/13/2015

METCOR INC.

660 BOUL. ARTHUR-SALVE
ST-EUSTACHE, QC J1R 5A8
Tel: 450-473-1884 / Fax: 450-401-6408

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
201869	1	87675

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT / Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

LIVRÉ À / Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
27040		A2	2015/1/13	client

QUANTITÉ Quantity	No. PIÈCE Part No	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	----------------------	------------------------------	---	-----------------

74 646 3316

23,

(10) 646 3316 127462

(30) 646 9711 128097

(10) 646 9711 127326

(12) 646 3013 127805

(12) 646 3314 127669

SP15-01-26

2-BOÎTE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS No. Containers	COMMENTAIRES CONTENEUR Container Comments
-------------------------------------	-----------------------------------	--

BOÎTE DE CARTON

2

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped 74

POIDS EXPÉDIÉ / Weight Shipped 23,00

QUANTITÉ RESTANTE / Quantity Remaining 0

POIDS RESTANT / Weight Remaining 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped 74

POIDS EXPÉDIÉ / Weight Shipped 23,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On 2015/01/16

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Rapport d'Inspection**Inspection Report**

BON DE TRAVAIL order	CHARGEMENT load
201869	

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
27040		A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS
HARDNESS	58 - 62 HRC	8	60 - 62 HRC

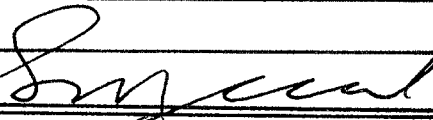
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
74	23	848.3318 (10) 848.3318 127482 (30) 848.9711 128097 (10) 848.9711 127326 ✓ (12) 848.3013 127805 (12) 848.3314 127669 2 BOITE DE CARTON

SP15-01-26

28 Jan

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2015-01-16

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
201869	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
27040		A2		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	8	60 - 62 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
74	23	646.3316 (10) 646.3316 127462 (30) 646.9711 128097 (10) 646.9711 127326 (12) 646.3013 127805 (12) 646.3314 127669 2 BOITE DE CARTON		

SP15-01-26

COMMENTAIRES / comments

DOUBLE TEMPER 400F, 2 HRS

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

APPROUVÉ par / Approved by:

Isabel Otero

Isabel Otero
QA Technician

DATE: 2015-01-16

